



SLOVENSKI STANDARD
SIST EN 28744:1996

01-april-1996

Stožčasti zatiči z zarezo

Grooved pins - Full-length taper grooved (ISO 8744:1986)

Kegelkerbstifte (ISO 8744:1986)

Goupilles cannelées à cannelures progressives sur toute la longueur (débouchantes)
(ISO 8744:1986)

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Ta slovenski standard je istoveten z: EN 28744:1992

<https://standards.iteh.ai/catalog/standards/sist/46f476a8-4e75-4353-9b09-cb964f6627f6/sist-en-28744-1996>

ICS:

21.060.50 Zatiči, žebli Pins, nails

SIST EN 28744:1996

en

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EUROPEAN STANDARD

EN 28744:1992

NORME EUROPÉENNE

EUROPÄISCHE NORM

July 1992

UDC 621.886.124

Descriptors: Fasteners, grooved pins, specifications, dimensions, designation

English version

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This European Standard was approved by CEN on 1992-07-17. CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration.

Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

The European Standards exist in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: rue de Stassart, 36 B-1050 Brussels

FOREWORD

In 1992, CEN Technical Committee CEN/TC 185 "Threaded and non threaded mechanical fasteners and accessories" the secretariat of which is held by DIN decided to submit the International Standard

ISO 8744:1986 - "Grooved pins - Full-length taper grooved"

to the formal vote procedure.

The result was positive.

In the countries bound to implement this European Standard a national standard identical to this European standard shall be published at the latest by 1993-01-31 and conflicting national standards shall be withdrawn at the latest by 1993-01-31.

According to the CEN/CENELEC Common Rules the following countries are bound to implement this European Standard : Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Spain, Portugal, Sweden, Switzerland and United Kingdom.

Endorsement notice

The text of the International Standard ISO 8744:1986 was approved by CEN as a European Standard without any modification.

International Standard



8744

INTERNATIONAL ORGANIZATION FOR STANDARDIZATION • МЕЖДУНАРОДНАЯ ОРГАНИЗАЦИЯ ПО СТАНДАРТИЗАЦИИ • ORGANISATION INTERNATIONALE DE NORMALISATION

Grooved pins — Full-length taper grooved

Goupilles cannelées à cannelures progressives sur toute la longueur (débouchantes)

First edition — 1986-11-01

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UDC 621.886.12

Ref. No. ISO 8744-1986 (E)

Descriptors : fasteners, pins (mechanics), grooved pins, specifications, dimensions, designation.

Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work.

Draft International Standards adopted by the technical committees are circulated to the member bodies for approval before their acceptance as International Standards by the ISO Council. They are approved in accordance with ISO procedures requiring at least 75 % approval by the member bodies voting.

International Standard ISO 8744 was prepared by Technical Committee ISO/TC 2, *Fasteners*.

Users should note that all International Standards undergo revision from time to time and that any reference made herein to any other International Standard implies its latest edition, unless otherwise stated.

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Grooved pins — Full-length taper grooved

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1 Scope and field of application

SIST EN 28744:1996

This International Standard specifies the characteristics of full-length taper grooved pins which have three equally spaced grooves impressed longitudinally on their exterior surface, with metric dimensions and nominal diameter, d_1 , from 1,5 to 25 mm inclusive.

The displaced material to each side of the grooves forming an expanded diameter d_2 which is larger than the nominal diameter d_1 will cause a positive locking fit when these grooved pins are forced into a drilled hole equal to the nominal diameter d_1 (see clause 4).

2 References

ISO 2081, *Metallic coatings — Electroplated coatings of zinc on iron or steel.*

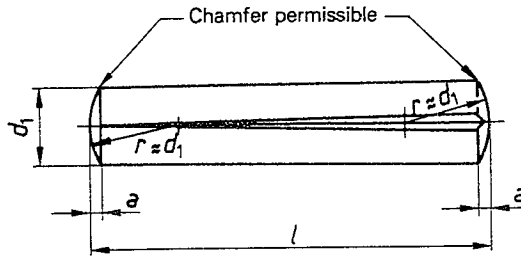
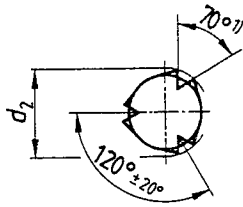
ISO 3269, *Fasteners — Acceptance inspection.*

ISO 4520, *Chromate conversion coatings on electroplated zinc and cadmium coatings.*

ISO 8749, *Pins and grooved pins — Shear test.*

ISO 8744-1986 (E)

3 Dimensions



Dimensions in millimetres

d_1	nom.		1,5	2	2,5	3	4	5	6	8	10	12	16	20	25		
	tol.		h9				h11										
a	≈		0,2	0,25	0,3	0,4	0,5	0,63	0,8	1	1,2	1,6	2	2,5	3		
Minimum shear strength, double ²⁾ kN			1,6	2,84	4,4	6,4	11,3	17,6	25,4	45,2	70,4	101,8	181	283	444		
nom.			Expanded diameter, $d_2^{4),5)}$														
$l^{3)}$			+ 0,05 0						± 0,05						± 0,10		
min.			1,63			2,70			3,25			4,35			5,35		
max.			1,60			2,15			3,20			4,30			5,30		
8	7,75	8,25															
10	9,75	10,25															
12	11,5	12,5															
14	13,5	14,5															
16	15,5	16,5															
18	17,5	18,5															
20	19,5	20,5															
22	21,5	22,5															
24	23,5	24,5															
26	25,5	26,5															
28	27,5	28,5															
30	29,5	30,5															
32	31,5	32,5															
35	34,5	35,5															
40	39,5	40,5															
45	44,5	45,5															
50	49,5	50,5															
55	54,25	55,75															
60	59,25	60,75															
65	64,25	65,75															
70	69,25	70,75															
75	74,25	75,75															
80	79,25	80,75															
85	84,25	85,75															
90	89,25	90,75															
95	94,25	95,75															
100	99,25	100,75															
120	119,25	120,75															

- 1) The grooving angle 70° applies only to grooved pins made from steel as shown in clause 5. The grooving angle may be modified depending on resilience of material.
- 2) Applies only to grooved pins made from steel as shown in clause 5.
- 3) The range of commercial lengths is between the stepped lines.
- 4) The expanded diameter d_2 applies only to pins made from steel as shown in clause 5. For other materials, for example stainless steel, a reduction amount shall be subtracted from the given values and should be agreed between customer and supplier.
- 5) For testing d_2 , a GO/NO GO ring gauge should be used.